

# Work Order ID 91908

\*91908\*

Page 1

October-19-12 2:22:50 PM

Item ID: D350-591-311

Accept

\*N9000040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12 Start Qty: 10.00

\*10\*

Cust Item ID: \

Required Date: 11/16/12 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: MLJ Date: 12-10-22 Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

| Draw Nbr | Revision Nbr |
|----------|--------------|
|----------|--------------|

|       |       |
|-------|-------|
| D3272 | Rev B |
|-------|-------|

100

0.00

\*100\*

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

110

0.00

\*110\*

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod 122358

122399

3-Grind End Plate flush

10 MLJ 12-11-20  
(10)

10 φ 12.11.12

**\*91908\***

October-19-12 2:22:50 PM

**\*N900040100\***

Setup Start \*NS1\*

Stop \*NS2\*

**\*10\***

**Cust Item ID:**

**\*10\***

**Customer:**

**Reference:**

Run Start \*NR1\*

Stop \*NR2\*

**QC:** \_\_\_\_\_ **Date:** \_\_\_\_\_ **SPC (Y/N):** \_\_\_\_\_ **Date:** \_\_\_\_\_

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

**\*120\***

QC

## Memo

0.00

## Quality Control

130

QC5- Inspect part completeness to step on W/O

0.00

\*130\*

QC

## Memo

0.00

## Quality Control

140

Chemical Conversion Coat per QSI005 4.1

0.00

**\*140\***

HandFinish

## Memo

0.00

## Hand Finishing

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Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                         | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 150                            | QC: Inspect Part Finish                          | 0.00                 |         |        |              | 10            | 0             |                  | DA<br>23<br>89 |
| *150*                          |  |                      |         |        |              |               |               |                  |                |
| QC                             | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |
| 180                            |  | 0.00                 |         |        |              | 10            | 0             |                  | 12.11.14       |
| *180*                          | Large Fab  |                      |         |        |              |               |               |                  | 12.11.15       |
| Large Fab                      | Memo   | 0.00                 |         |        |              |               |               |                  |                |
| Large Fab                      | 1-Assemble Leg Assembly as per Dwg D3272.        |                      |         |        |              |               |               |                  |                |
|                                | 2-Leave one rivet out until welding is complete. |                      |         |        |              |               |               |                  |                |
|                                | 3-Bevel Aft end for welding                      |                      |         |        |              |               |               |                  |                |
|                                | 4-Inspect for foreign object as per QSI 024      |                      |         |        |              |               |               |                  |                |
|                                | 5-Weld Aft End Plate as per QSI 004 & Dwg D3272  |                      |         |        |              |               |               |                  |                |
|                                | A/RAluminum Rod 122358                           |                      |         |        |              |               |               |                  |                |
|                                | 6-Grind End Plate flush                          |                      |         |        |              |               |               |                  |                |
|                                | 7-Install last rivet as per Dwg.                 |                      |         |        |              |               |               |                  |                |

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Stop \*NS2\*

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Start Date: 10/19/12 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                      | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 190                            | QC10- Inspect visual per QSI004- ground welds | 0.00                 |         |        |              |               |               |                  |                |
| *190*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 200                            | QC5- Inspect part completeness to step on W/O | 0.00                 |         |        |              |               |               |                  |                |
| *200*                          |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |
| 210                            | Chemical Conversion Coat per QSI005 4.1       | 0.00                 |         |        |              |               |               |                  |                |
| *210*                          |   |                      |         |        |              |               |               |                  |                |
| HandFinish                     | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Hand Finishing                 |   |                      |         |        |              |               |               |                  |                |

DAS  
09  
8-89

DAS  
09  
8-89

10 X 0

mf

12/11/16

# Work Order ID 91908

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Item ID: D350-591-311

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\*N900040100\*

Setup Start \*NS1\*

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Stop \*NS2\*

Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12 Start Qty: 10.00

\*10\*

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 10.00

\*10\*

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start \*NR1\*

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                     | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 220                            | White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum | 0.00                 |         |        |              |               |               |                  |                |
| *220*                          |  |                      |         |        |              |               |               |                  |                |
| Powdercoat                     |  |                      |         |        |              |               |               |                  |                |
| Powder Coating                 |  |                      |         |        |              |               |               |                  |                |
| mi 22878                       |  |                      |         |        |              |               |               |                  |                |
| 230                            | Wing Walk as per dwg QSI005 4.4 Batch        | 0.00                 |         |        |              |               |               |                  |                |
| *230*                          |  |                      |         |        |              |               |               |                  |                |
| HandFinish                     |  |                      |         |        |              |               |               |                  |                |
| Hand Finishing                 |  |                      |         |        |              |               |               |                  |                |
| 240                            | QC3- Inspect Part Finish                     | 0.00                 |         |        |              |               |               |                  |                |
| *240*                          |  |                      |         |        |              |               |               |                  |                |
| QC                             |  |                      |         |        |              |               |               |                  |                |
| Quality Control                |  |                      |         |        |              |               |               |                  |                |

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

Memo

Memo

10 X 12/11/19  
LH  
10 12/11/19  
10 12/11/19

# Work Order ID 91908

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Item ID: D350-591-311 Accept \*N900040100\* Setup Start \*NS1\*  
 Revision ID: Stop \*NS2\*  
 Item Name: Heli-Access-Step, Long LH  
 Start Date: 10/19/12 Start Qty: 10.00 \*10\* Cust Item ID:  
 Required Date: 11/16/12 Req'd Qty: 10.00 \*10\* Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start \*NR1\*  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop \*NR2\*

| Sequence ID/<br>Work Center ID | Operation<br>Description                              | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp  |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|-----------------|
| 250                            | Pick Kit  | 0.00                 |         |        |              |               |               |                  |                 |
| *250*                          |   |                      |         |        |              | 10x           |               |                  | SP 8/12-11-19   |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                 |
| Packaging                      |   |                      |         |        |              |               |               |                  |                 |
| 260                            | QC4- 100% Inspect kits for completeness               | 0.00                 |         |        |              | 10            |               |                  |                 |
| *260*                          |   |                      |         |        |              |               |               |                  |                 |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  | DAS 15 12-11-19 |
| Quality Control                |   |                      |         |        |              |               |               |                  |                 |
| 270                            |   | 0.00                 |         |        |              |               |               |                  |                 |
| *270*                          | Packaging   |                      |         |        |              | 82            | 12/11/22      |                  | DAS 20 12-11-22 |
| Packaging                      | Memo  | 0.00                 |         |        |              |               |               |                  |                 |
| Packaging                      | Identify and pack for shipping as per PPPD350-591-311 |                      |         |        |              |               |               |                  |                 |
|                                | Location: HALL Reob                                   |                      |         |        |              |               |               |                  |                 |

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Item ID: D350-591-311

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**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12 Start Qty: 10.00

**\*10\***

Cust Item ID:

Required Date: 11/16/12 Req'd Qty: 10.00

**\*10\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***

| Sequence ID/<br>Work Center ID | Operation<br>Description                    | Set Up/<br>Run Hours | Tool ID | Tool # | Plan<br>Code | Accept<br>Qty | Reject<br>Qty | Reject<br>Number | Insp.<br>Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 280                            | QC21- Final Inspection - Work Order Release | 0.00                 |         |        |              |               |               |                  |                |
| <b>*280*</b>                   |   |                      |         |        |              |               |               |                  |                |
| QC                             | Memo  | 0.00                 |         |        |              |               |               |                  |                |
| Quality Control                |   |                      |         |        |              |               |               |                  |                |

12/11/22  
mf  
12-11-22

# Picklist Print

October-19-12 2:22:48 PM

Page 1

Work Order ID: 91908

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12

Required Date: 11/16/12

Start Qty: 10.00

Required Qty: 10.00

Comments: IPP Rev:A04.03.22New issue KJ/RF  
IPP Rev:B 07-06-09 Added D3272-1 JLM  
IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC  
route seq in bom DD 10.04.28 verified by:EC

IPP Rev:D fixe

| Component Item ID/<br>Item Name | Replacement<br>Item ID | Mfg/<br>Purch | Bin<br>Item | Primary<br>Location | Last<br>Location | Route<br>Seq ID | Unit of<br>Measure | Qty on<br>Hand | Qty per Kit | Total<br>Qty | Qty<br>Issued | Date<br>Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
| D3272-1<br>Step                 |                        | Manufactured  | No          |                     |                  | 110             | Each               | 20.0000        | 1           | 10           |               | 12.10.31       |        |

## Location

## Loc Qty

## Loc Code

ST B92141 → -10  
WA 30  
86573 5  
91756 10  
91757 5

10x

D3067-1

End:Plate

Manufactured

No

110

Each

226.0000

1

10

12.11.12

## Location

## Loc Qty

## Loc Code

WA 222  
78608 4  
83855 1  
90177 15  
90178 22  
90335 60  
90336 60  
90486 60  
WA016 4  
67582 2  
68214 1  
79607 1

10



# Picklist Print

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Work Order ID: 91908

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12

Required Date: 11/16/12

Start Qty: 10.00

Required Qty: 10.00

D3219-1  
Plate

Manufactured No

110 Each 274.0000 2 20

*12.11.12*

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| WA              | 256            |                 |
| 88888           | 12             |                 |
| 89966           | 108            |                 |
| 89967           | 108            |                 |
| 90704           | 28             |                 |
| WA016           | 18             |                 |
| 73410           | 12             |                 |
| 77674           | 6              |                 |

*20*

D3066-1  
Spacer

Manufactured No

180 Each 179.0000 2 20

*12.11.14*

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| WA              | 179            |                 |
| 90211           | 30             |                 |
| 90212           | 60             |                 |
| 90346           | 29             |                 |
| 90347           | 60             |                 |

*20*

MS20600-AD4W4  
Rivets

Purchased No

180 Each 1,578.0000 16 160

*12.11.14*

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| 321             | 18             |                 |
| 121652          | 18             |                 |
| ST311           | 1000           |                 |
| 123021          | 1000           |                 |
| ST321           | 560            |                 |
| 121011          | 9              |                 |
| 121340          | 39             |                 |
| 121444          | 512            |                 |

*160*

# Picklist Print

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Work Order ID: 91908

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12

Required Date: 11/16/12

Start Qty: 10.00

Required Qty: 10.00

D3065-041  
Step Leg Assembly Hi

Manufactured No

180 Each 21.0000 1 10

*12.11.14*

| Location         | Loc Qty | Loc Code |
|------------------|---------|----------|
| ST               | -30     |          |
| WA <u>B90012</u> | 21      |          |
| 66149            | 0       |          |
| 79336            | 1       |          |
| 88822            | 5       |          |
| 90011            | 15      |          |
| WA013            | 30      |          |

*10*

D3067-1  
End Plate

Manufactured No

180 Each 226.0000 1 10

*12.11.14*

| Location     | Loc Qty | Loc Code |
|--------------|---------|----------|
| WA           | 222     |          |
| 78608        | 4       |          |
| 83855        | 1       |          |
| 90177        | 15      |          |
| 90178        | 22      |          |
| 90335        | 60      |          |
| <u>90336</u> | 60      |          |
| 90486        | 60      |          |
| WA016        | 4       |          |
| 67582        | 2       |          |
| 68214        | 1       |          |
| 79607        | 1       |          |

*4/6*

**ANS-351**  
Bolt

Purchased No

250 Each 190.0000 2 20

*SP 12-11-20*

*Sm's 107*

| Location      | Loc Qty | Loc Code |
|---------------|---------|----------|
| FG            | 10      |          |
| 122800        | 10      |          |
| ST353         | 180     |          |
| <u>123352</u> | 180     |          |

*20x*

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Work Order ID: 91908

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12

Required Date: 11/16/12

Start Qty: 10.00

Required Qty: 10.00

D3235-1  
Mounting Lug

Manufactured No

250 Each 126.0000

2

20

SP

SP

Sms 10x

## Location

## Loc Qty

## Loc Code

ST470

126

90002

126

D3278-041  
Support Assembly

Sms 10x

Manufactured No

250 Each 0.0000

20x

B89973 1x

10

B89974

19 SP

AN960JD416  
Washer

NAS1149D0463J

Purchased No

250 Each 29.0000

16

160

m123355

SP

Sms 10x

## Location

## Loc Qty

## Loc Code

ST351

29

116289

8

119097

21

AN960JD516  
Washer

NAS1149D0563J

Purchased No

250 Each 2.0000

4

40

m123355 SP

Sms 10x

## Location

## Loc Qty

## Loc Code

ST338

2

1069059

2

AN5-36A  
Bolt

Purchased No

250 Each 46.0000

2

20

m123525 SP

Sms 10x

## Location

## Loc Qty

## Loc Code

ST338

46

123021

46

D2618  
Bushings

Manufactured No

250 Each 5.0000

2

20

B892530

SP 12-11-20

Sms 10x

## Location

## Loc Qty

## Loc Code

ST013

5

76130

2

84646

3

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12

Required Date: 11/16/12

Start Qty: 10.00

Required Qty: 10.00

**D2230-3**

Manufactured No

250

Each

316.0000

**4**

40

Lug

## Location

## Loc Qty

## Loc Code

FG

1

89045

1

ST469

315

89782

19

89950

200

90514

96

Manufactured No

250

f

409.2539

**12**

12

**D2856-400**

Abrasion Strip

## Location

## Loc Qty

## Loc Code

ST403

120.2525

81875

6.398

89352

113.8545

ST408

216

90764

216

ST409

73.0014

63735

0.6696

68076

0.3149

71164

8.46

86905

63.5569

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12

Required Date: 11/16/12

Start Qty: 10.00

Required Qty: 10.00

**MS21042L3**

Purchased

No

250

Each

3,340.0000

20

Nut

## Location

## Loc Qty

## Loc Code

316

651

122452

651

ST300

338

117885

32

119017

168

119075

138

ST314

1831

123265

1831

ST317

520

122141

520

**AN4-13A**

Purchased

No

250

Each

1,002.0000

80

Bolt

## Location

## Loc Qty

## Loc Code

ST356

809

122416

287

122808

22

122993

500

ST357

193

120187

19

120770

12

121652

161

122063

1

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 10/19/12

Required Date: 11/16/12

Start Qty: 10.00

Required Qty: 10.00

MS21042L5

Purchased

No

250

Each

1,253.0000

2

20

Nut

## Location

## Loc Qty

## Loc Code

300

173

121652

173

314

1000

122452

1000

ST300

80

108827

4

116105

1

116548

43

119109

20

2937

12

SMS 10x

20x

MS21042L4

Purchased

No

250

Each

5,326.0000

8

80

Nut

## Location

## Loc Qty

## Loc Code

314

1399

122452

1399

ST300

27

119017

20

121444

7

ST314

3900

123021

3000

123248

900

SMS 10x

80

AN960JD10

Washer

NAS1149D0363J

Purchased

No

250

Each

0.0000

4

40

SMS 10x

29x M123248 SP

N 11x M117291

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Shop Packet Print

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|                      |                      |  |                        |
|----------------------|----------------------|--|------------------------|
| DESIGN<br><i>GP</i>  | DRAWN BY<br><i>B</i> | <b>DART AEROSPACE LTD</b><br>HAWKESBURY, ONTARIO, CANADA |                        |
| CHECKED<br><i>LE</i> | APPROVED<br><i>H</i> | DRAWING NO.<br>D3272                                     | REV. B<br>SHEET 1 OF 3 |
| DATE<br>07.05.18     |                      | TITLE<br>STEP ASSEMBLY, HI LONG                          | SCALE<br>NFS           |
| A                    | 04.03.01             | NEW ISSUE  |                        |
| B                    | 07.05.18             | D3272-1 WAS D2622-120                                    |                        |

**RELEASED**

07.06.04 *H*

| QTY<br>-041 | QTY<br>-042 | PART NUMBER  | DESCRIPTION                   |
|-------------|-------------|--------------|-------------------------------|
| X           |             | D3272-041    | STEP ASSEMBLY, HIGH LONG (LH) |
|             | X           | D3272-042    | STEP ASSEMBLY, HIGH LONG (RH) |
|             |             |              |                               |
| 1           | 1           | D3065-041    | LEG ASSEMBLY                  |
| 2           | 2           | D3066-1      | SPACER                        |
| 2           | 2           | D3067-1      | END PLATE                     |
| 2           | 2           | D3219-1      | SUPPORT                       |
| 1           | 1           | D3272-1      | STEP                          |
|             |             |              |                               |
| 16          | 16          | MS20600AD4W4 | RIVET                         |
|             |             |              |                               |

B

**GENERAL NOTES:**

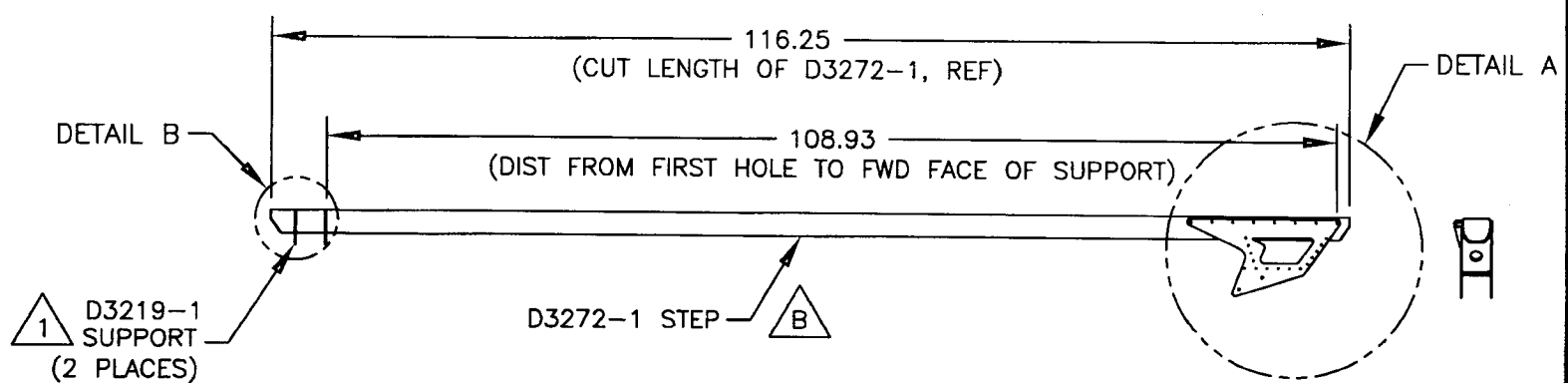
- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1  
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3  
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

12-10-22  
NO. 91908MCS  
WORK ORDER  
WITHOUT NOTICE  
SUBJECT TO AMENDMENT  
UNCONTROLLED COPY  
ENGINEERING  
RGT PARTS  
SHEETS

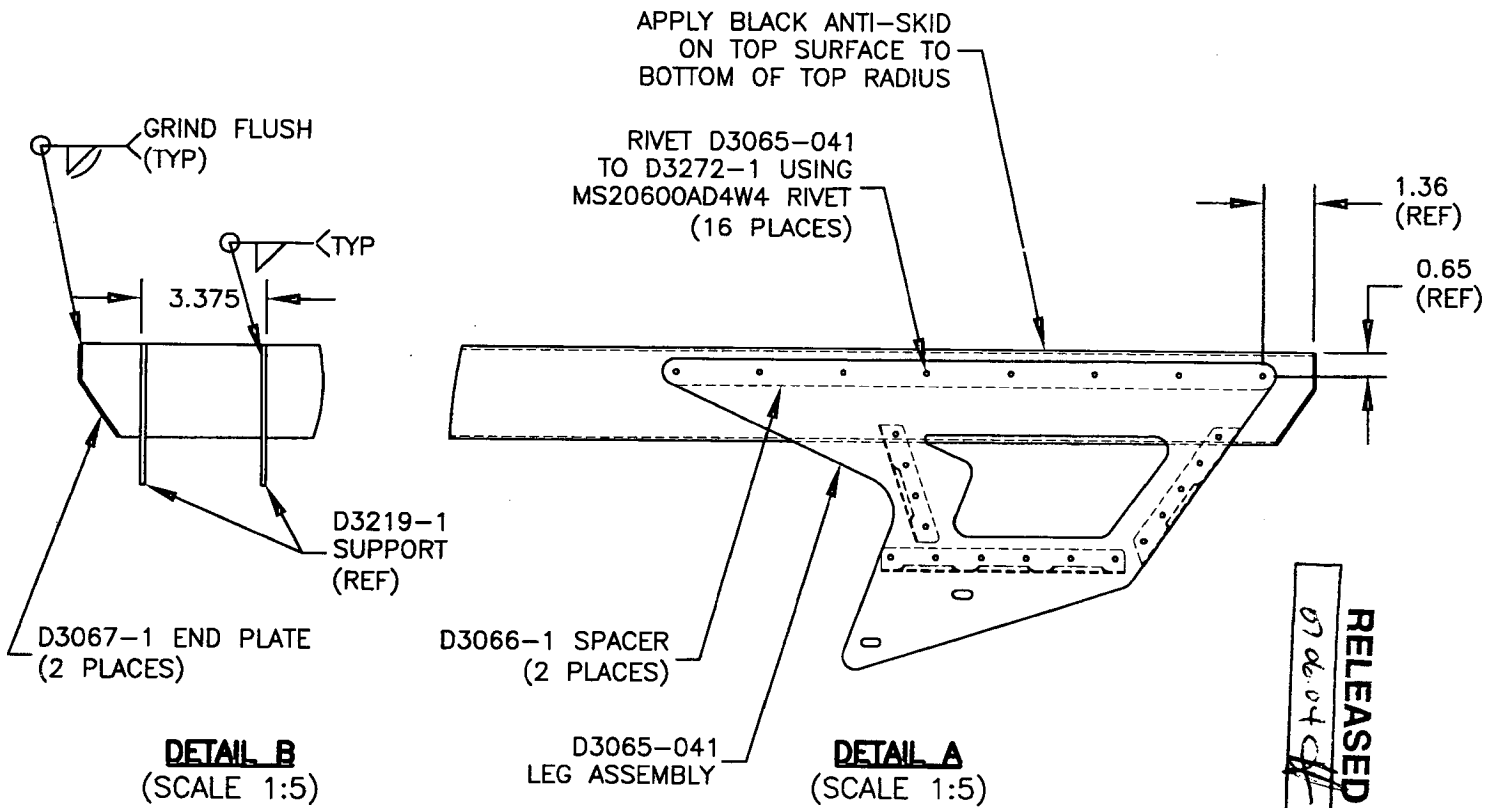
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91908



**D3272-041 STEP ASSEMBLY (LH. SHOWN)**  
**D3272-042 STEP ASSEMBLY (RH, OPPOSITE)**



RELEASED  
 07 de 04 08

|         |          |             |                        |                             |
|---------|----------|-------------|------------------------|-----------------------------|
| DESIGN  | 90       | DRAWN BY    |                        | DART AEROSPACE LTD          |
| CHECKED | CE       | APPROVED    |                        | HAWKESBURY, ONTARIO, CANADA |
| DATE    | 07.05.18 | DRAWING NO. | D3272                  | REV. B                      |
|         |          | TITLE       | STEP ASSEMBLY, HI LONG | SHEET 2 OF 3                |
|         |          | SCALE       | 1:20                   |                             |

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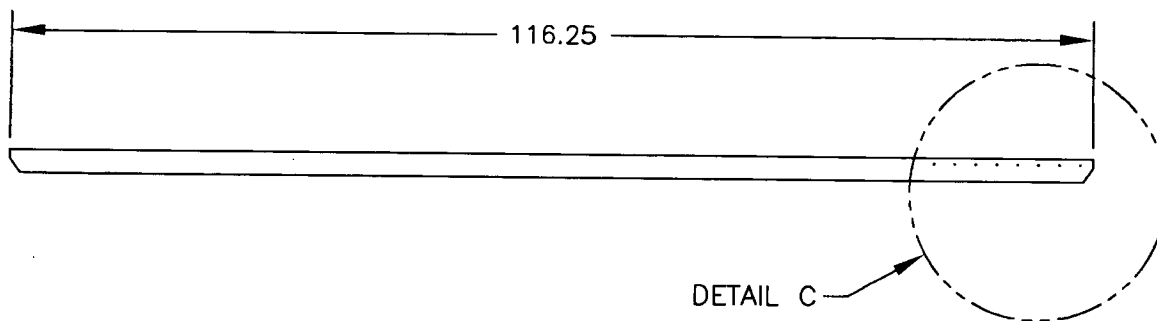
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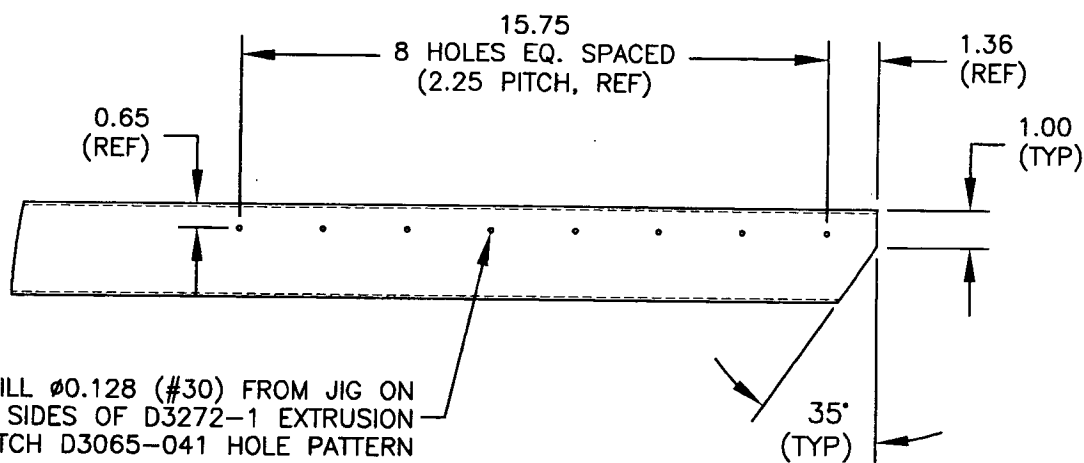
91908

**DART**

|         |           |          |          |   |
|---------|-----------|----------|----------|---|
| DESIGN  | <i>q</i>  | DRAWN BY | <i>J</i> | DART AEROSPACE LTD<br>HAMKESBURY, ONTARIO, CANADA |
| CHECKED | <i>CE</i> | APPROVED | <i>J</i> | DRAWING NO. D3272                                 |
| DATE    | 07.05.18  |          |          | REV. B<br>SHEET 3 OF 3                            |
|         |           |          |          | TITLE<br>STEP ASSEMBLY, HI LONG                   |
|         |           |          |          | SCALE<br>1:20                                     |



**B** **D3272-1 STEP**  
(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL  $\varnothing 0.128$  (#30) FROM JIG ON  
BOTH SIDES OF D3272-1 EXTRUSION  
TO MATCH D3065-041 HOLE PATTERN

**DETAIL C**  
(SCALE 1:5)

**RELEASED**

07.06.04

REF

ONLY

Sms

## DART AEROSPACE LTD.

D350-591  
Page 23 of 23

| Qty<br>-211 | Qty<br>-212 | Qty<br>-213 | Qty<br>-214 | Qty<br>-215 | Qty<br>-216 | Qty<br>-311   | Qty<br>-312   | Part Number              | Description                                   |
|-------------|-------------|-------------|-------------|-------------|-------------|---------------|---------------|--------------------------|---|
| X           |             |             |             |             |             |               |               | D350-591-211             | Heli-Access-Step™, Long Step – High Skid, LH  |
|             | X           |             |             |             |             |               |               | D350-591-212             | Heli-Access-Step™, Long Step – High Skid, RH  |
|             |             | X           |             |             |             |               |               | D350-591-213             | Heli-Access-Step™, Short Step – High Skid, LH |
|             |             |             | X           |             |             |               |               | D350-591-214             | Heli-Access-Step™, Short Step – High Skid, RH |
|             |             |             |             | X           |             |               |               | D350-591-215             | Heli-Access-Step™, Short Step – Low Skid, LH  |
|             |             |             |             |             | X           |               |               | D350-591-216             | Heli-Access-Step™, Short Step – Low Skid, RH  |
|             |             |             |             |             |             | X             |               | D350-591-311             | Heli-Access-Step™, Long Step – High Skid, LH  |
|             |             |             |             |             |             |               | X             | D350-591-312             | Heli-Access-Step™, Long Step – High Skid, RH  |
| 1           |             |             |             |             |             |               |               | D3070-041                | STEP ASSEMBLY (HIGH-LONG, LH)                 |
|             | 1           |             |             |             |             |               |               | D3070-042                | STEP ASSEMBLY (HIGH-LONG, RH)                 |
|             |             | 1           |             |             |             |               |               | D3078-041                | STEP ASSEMBLY (HIGH-SHORT, LH)                |
|             |             |             | 1           |             |             |               |               | D3078-042                | STEP ASSEMBLY (HIGH-SHORT, RH)                |
|             |             |             |             | 1           |             |               |               | D3168-041                | STEP ASSEMBLY (LOW-SHORT, LH)                 |
|             |             |             |             |             | 1           |               |               | D3168-042                | STEP ASSEMBLY (LOW-SHORT, RH)                 |
|             |             |             |             |             |             | 1             |               | D3272-041                | STEP ASSEMBLY (HIGH-LONG, LH)                 |
|             |             |             |             |             |             |               | 1             | D3272-042                | STEP ASSEMBLY (HIGH-LONG, RH)                 |
| 4           | 4           |             |             |             |             |               |               | D2182B035                | RUBBER CUSHION                                |
|             |             | 2           | 2           | 2           | 2           |               |               | D2230-1                  | MOUNTING LUG                                  |
|             |             | 2           | 2           | 2           | 2           | <del>4</del>  | <del>4</del>  | <del>D2230-3</del>       | <del>MOUNTING LUG</del>                       |
| 8           | 8           |             |             |             |             | <del>2</del>  | <del>2</del>  | <del>D2274</del>         | <del>RADIUS BLOCK</del>                       |
|             |             |             |             |             |             | <del>2</del>  | <del>2</del>  | <del>D2618</del>         | <del>BUSHING</del>                            |
| 4           | 4           | 4           | 4           | 4           | 4           |               |               | D2732-030                | CUSHION                                       |
| 2           | 2           | 1           | 1           | 1           | 1           | <del>2</del>  | <del>2</del>  | <del>D2856-400-720</del> | <del>ABRASION STRIP</del>                     |
| 2           | 2           |             |             |             |             |               |               | D3064-1                  | CLAMP   |
| 1           | 1           |             |             |             |             |               |               | D3079-041                | SUPPORT ASSEMBLY                              |
| 4           | 4           |             |             |             |             |               |               | D3080-1                  | CLAMP   |
|             |             |             |             |             |             | <del>2</del>  | <del>2</del>  | <del>D3235-1</del>       | <del>MOUNTING LUG</del>                       |
|             |             |             |             |             |             | <del>1</del>  | <del>1</del>  | <del>D3278-041</del>     | <del>SUPPORT ASSEMBLY</del>                   |
| 2           | 2           | 2           | 2           | 2           | 2           | <del>2</del>  | <del>2</del>  | <del>AN3-35A</del>       | <del>BOLT</del>                               |
| 10          | 10          | 2           | 2           | 2           | 2           |               |               | AN4-11A                  | BOLT  |
|             |             | 4           | 4           | 4           | 4           | <del>8</del>  | <del>8</del>  | <del>AN4-13A</del>       | <del>BOLT</del>                               |
|             |             |             |             |             |             | <del>2</del>  | <del>2</del>  | <del>AN5-36A</del>       | <del>BOLT</del>                               |
| 4           | 4           | 4           | 4           | 4           | 4           | <del>4</del>  | <del>4</del>  | <del>AN960JD10</del>     | <del>WASHER</del>                             |
| 20          | 20          | 12          | 12          | 12          | 12          | <del>16</del> | <del>16</del> | <del>AN960JD416</del>    | <del>WASHER</del>                             |
|             |             |             |             |             |             | <del>4</del>  | <del>4</del>  | <del>AN960JD516</del>    | <del>WASHER</del>                             |
| 2           | 2           | 2           | 2           | 2           | 2           | <del>2</del>  | <del>2</del>  | <del>MS21042L3</del>     | <del>NUT</del>                                |
| 10          | 10          | 6           | 6           | 6           | 6           | <del>8</del>  | <del>8</del>  | <del>MS21042L4</del>     | <del>NUT</del>                                |
|             |             |             |             |             |             | <del>2</del>  | <del>2</del>  | <del>MS21042L5</del>     | <del>NUT</del>                                |
|             |             |             |             |             |             | <del>1</del>  | <del>1</del>  | <del>*DSI 9410-011</del> | <del>STEP MODIFICATION KIT</del>              |

\*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.

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Revision: **G**

Date: 08.10.06